

Date: Monday, 1/7/2008 3:38:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HINGE BRACKET		
Job Number	: 36628		Part Number	: D28582		
Estimate Number	: 10349		Drawing Number	: D2858 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 1/7/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	: MACHINED PARTS			
Previous Run	: 31792		Due Date	: 1/31/2008	Qty:	24
Written By	:		Um:	Each		
Checked & Approved By	:		JL 08.01.8			
Comment	:		Est C 00-06-22 Removed P/O for powder coat EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"	
Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s) Material: 1.50" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B15001250) Batch 1104183			
2.0	BAND SAW	BAND SAW	
Comment: BAND SAW Cut blanks 6.02" Note: 1 Blank Makes 3 Parts			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2858-2			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: ~~01/01/22~~
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 36628

Part Number: D28582

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8-F 08/02/15

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

JL 08/02/15

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JL 08/02/15

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



24

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

bx 08-02-19

9.0 POWDER COATING POWDER COATING



24X

M107005

Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

m- 08/02/19

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



AL

24

Comment: INSPECT POWDER COAT

08-02-19

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51

8/2/19 56 24X

12.0 QC21 FINAL INSPECTION/W/O RELEASE



24

Comment: FINAL INSPECTION/W/O RELEASE

12/08/2012

Job Completion



2008/2/20

24

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36628
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg:	D2858	Rev:	B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

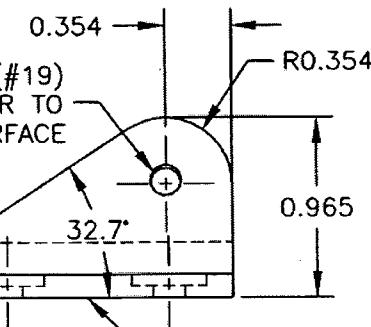
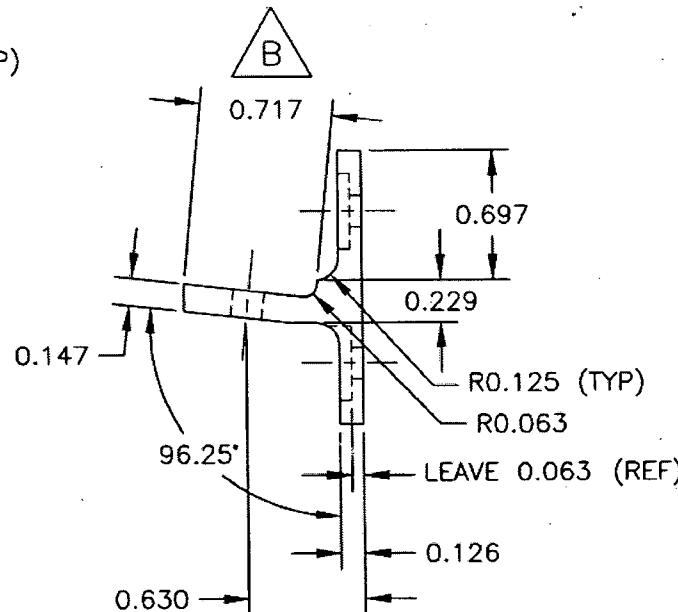
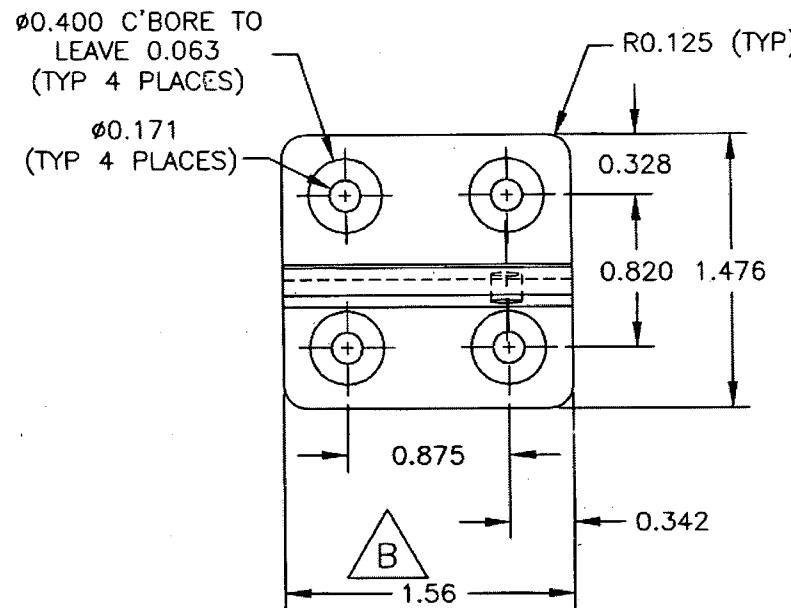
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.173	✓			
Ø0.400	+0.005/-0.000	.401	✓			
R0.125	+/-0.010	.125	✓			
0.328	+/-0.010	.328	✓			
0.820	+/-0.005	.820	✓			
1.476	+/-0.010	1.476	✓			
0.342	+/-0.010	.343	✓			
0.875	+/-0.010	.875	✓			
1.56	+/-0.030	1.564	✓			
0.147	+/-0.010	.153	✓			
0.717	+/-0.010	.718	✓			
0.697	+/-0.010	.694	✓			
0.229	+/-0.010	.236	✓			
R0.125	+/-0.010	.125	✓			
R0.063	+/-0.010	.063	✓			
0.063	+/-0.010	.062	✓			
0.126	+/-0.010	.126	✓			
0.630	+/-0.010	.629	✓			
R0.354	+/-0.010	.354	✓			
0.965	+/-0.010	.969	✓			
Ø0.166	+0.005/-0.000	.168	✓			

Measured by:	J.L
Date:	08/02/14

Audited by:	J.F
Date:	08/02/15

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	J.F



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN

D2858-2 OPPOSITE

NO. 36628

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
44.01.09 KE

DART

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SUSPENDED

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>Up</i>	<i>JK</i>	D2858	
DATE		99.02.28	
A		98.12.14	NEW ISSUE
B		99.02.28	0.717 WAS 0.667, 1.56 WAS 1.559
		TITLE	HINGE BRACKET
		SHEET 1 OF 1	
		SCALE	1:1